Monday, 6/5/2006 7:46:59 AM

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

**Job Number** : 27361 : 11845

**Estimate Number** :NA

P.O. Number This Issue

: 6/5/2006 : NC Prsht Rev.

MIM

: NIA

S.O. No. : N/A

: MACHINED PARTS

**Drawing Name** 

Part Number **Drawing Number** 

**Due Date** 

Project Number

: N/A ; B **Drawing Revision** Material

: NIA : 6/20/2006

: SPACER

: D2346

: D2346 REV B

Written By

First Issue

**Previous Run** 

Checked & Approved By Comment

: Est.

Re-format to machine in house NG

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 Tube .375 x.035W

M6061T6T0375W035 1.0





0.1094 f(s)/Unit Total: 2.1882 f(s)

6061-T6 Tube .375 x.035W

Material:6061-T6 (WW-T-700/6) .375 Ø x 0.035 wall.

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

Deburr

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA198 N/A Machined Manually

20

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPEC

PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MAR

20

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CH					
DATE	STEP	PROCEDURE CHANGE By		Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
			-				

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	A		
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector

Part No:	PAR #:	Fault Category:	NCR:	Yes (No) DQA:	Date: 06/06/03
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Monday, 6/5/2006 7:46:59 AM Date: User: Kim Johnston **Process Sheet Drawing Name: SPACER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27361 Part Number: D2346 Job Number: Description: Sea. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 20 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ DC 8.0 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

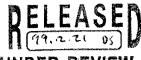
Dart A	erospac	e Ltd							
W/O:			WO	RK ORDER CHANGES					
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
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NCR:			WORK ORDE	R NON-CONFORMANO	CE (NCI	₹)			
DATE	STEP	Description of NC	Description of NC Corrective Action Section B			Verification		Approval	Approval
DATE	SILF	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign Date	& Sect	ion C	Design Mgr	QC Inspector
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Part No:	D 4 D 4	Fault Category:	NCR: Yes No DQA:	Date:





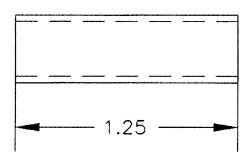
DESIG E	и ЗW	DRAWN BY	DART AEROSPA( HAWKESBURY, ONTARIO,	
CHEC	(EO	APPROVED	DRAWING NO.	REV. 8
9	*	%	D2346	SHEET 1 OF 1
DATE			TITLE	SCALE
99.1	2.15		SPACER	2:1
A		95.01.05	NEW ISSUE	
В		99.12.15	ADD FINISHING	



UNDER REVIEW

01.63.15 CP

# DESIGN OK, BUT CHECK WITH TB BEFORE MANUFACTURE



MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA × 0.035 WALLOP COPY FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTICE OF SUBJECT TO AMENDMENT SUBJECT TO AMENDMENT SUBJECT TO AMENDMENT

WORK ORDER

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DART AEROSPACE LTD		
DAKT AEROSPACE LID	Work Order:	277/
		a/J6/
Description: SPACER		
Description: SPACER	Part Number:	V 3391
		20/0
Inspection Dwg: D 2346 Rev: 8		Da 4 - 5 4
92010		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	×	First Art	icle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	i	Reject	Method of Inspection	Comments
1.25	±,030	1,250				
,375	+.010	375				
.035	+.010	,038				
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Measured by:		udited by:	MS	F	Prototype Appro	oval:
Date:	06/06/16	Date:	06/06/16			Date:

Measured by:	AS	Audited by:	MS	Prototype Approval:	
Date:	06/06/16	Date:	06/06/16	Date:	
Rev Date	Change				

Rev		Change	•	Revised by	Approved
A_	<u> </u>	New Issue		KJ/RF	